

Work Order ID 74685-3

Wednesday, October 05, 2011 9:58:35 AM

Item ID: D3602-1

Revision ID:

Item Name: Angle

Start Date: 10/5/2011 Start Qty: 20.00

Required Date: 10/11/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: *YMK*

QC:

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D3602

Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

I-Cut as per Dwg D3602
Deburr if necessary

Dwg Rev: *B*

0.00

Prog Rev: *B*

2-

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8 units

Accept

Cust Item ID:

Customer:

Date:

Date:

Run Start

Stop

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp



R11-10-24

R11-10-24

counts
(+24)

11.10.21

11.10.26

certs.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Form as per Dwg D3602

0.00

0.00

SB 10/12/10

8

140



QC

Quality Control

QC'S- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/12/10

8

150



Packaging

Packaging

Identify as per dwg & Stock Location 241A

Memo

0.00

0.00

10/12/10 8

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/12/06
me
11-12-06

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Picklist Print

Wednesday, October 05, 2011 9:58:31 AM

Page 1

Work Order ID: 74685

Parent Item: D3602-1

Parent Item Name: Angle



Start Date: 10/5/2011

Required Date: 10/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-27 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	147.0795	0.585	12.31579			

M304S20GA



304/316 040 Sheet



12.31579

Location

MAT020

Loc Qty

147.0795

Loc Code

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

118964

59.5

119347

119347

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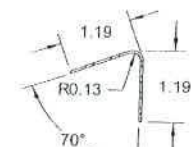
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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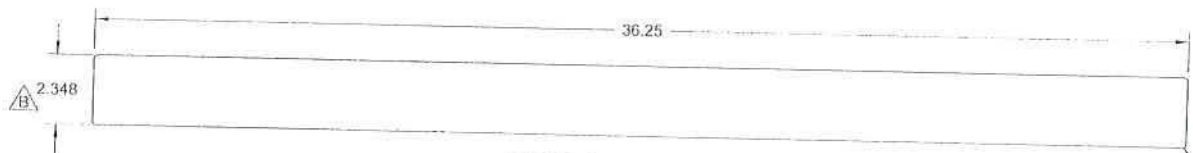
NOTE: Date & initial all entries



D3602-1 ANGLE
(MAKE FROM D3602-1F)



SECTION A-A
SCALE 2X



D3602-1F FLAT PATTERN

R0.13
TYP

RELEASED
07/03/11

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs

74685

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3602		REV. B	
TITLE: ANGLE		SCALE: NTS	
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